

Date: Thursday, 17/04/2008 2:02:15 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOOR SLUG |
| Job Number | : 38678 | | |
| Estimate Number | : 10162 | | |
| P.O. Number | : | Part Number | : D2587 |
| This Issue | : 17/04/2008 | Drawing Number | : D2587 REV A1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / | Drawing Revision | : A1 |
| Previous Run | : 36044 | Material | : |
| Written By | : | Due Date | : 25/04/2008 |
| Checked & Approved By | : <u>JLD 08-4-17</u> | Qty: | 20 Um: Each |
| Comment | : Est D 04.05.31 Step 2 changed KJ/JLM Est E 06.07.31 Waterjet EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet |
|-----|-------------|--------------------|



17



Comment: Qty.: 0.0168 sf(s)/Unit Total: 0.3360 sf(s)

6061T6 alum. sheet 0.040" thick

Batch: 100742 B 8-4-18

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2587

Dwg Rev: A1 B 8-4-18Prog Rev: A1

2-Deburr if necessary

RB 08/04/22

34

83

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

B 8-4-18**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECKS 08/04/22

34

counts

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L08/04/28

34X Counted

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 2:02:15 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SLUG

Job Number: 38678

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

08-04-28

K34

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST34

AS

08/04/28

(34)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



mf. 08-04-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

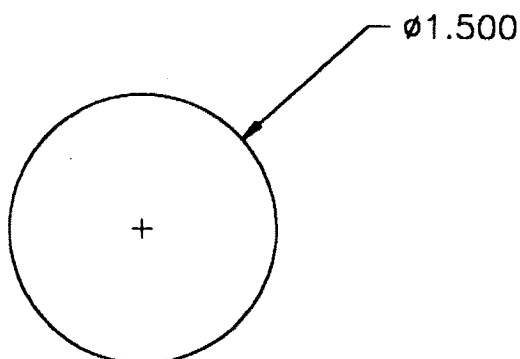
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries




| | | | |
|--------------------------|------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| MIKE M | B WILLIAMS | DRAWING NO. | REV. A |
| CHECKED | APPROVED | D2587 | SHEET 1 OF 1 |
| M. M. | M. M. | | |
| DATE | TITLE | | SCALE |
| 96:07:11 | DOOR SLUG | | 1:1 |
| AI K 03.09.16 | | ADD 6061-T6 OPTION | |

RELEASED
9607/23 BU



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38678

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE